


Date: Wednesday, 5/3/2006 2:08:54 PM  
User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	HANDLE WELDMENT
<b>Job Number</b> :	26924		
<b>Estimate Number</b> :	12050		
<b>P.O. Number</b> :	NIA	<b>Part Number</b> :	D3355047
<b>This Issue</b> :	5/3/2006	<b>Drawing Number</b> :	D3355 REV A
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	NIA	<b>Drawing Revision</b> :	A
<b>Previous Run</b> :	NIA	<b>Material</b> :	NIA
<b>Written By</b> :		<b>Due Date</b> :	5/10/2006
<b>Checked &amp; Approved By</b> :		<b>Qty:</b>	4
<b>Comment</b> :	est rev A 06.01.20 new issue EC		

Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D33555 medium tubing



made by hand



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)  
pick: 2.35

M1018TR1-2500.120

9.40

36.10

Qty Part number Description Batch  
1 D3355-5 medium tubing M16210

2.35

CPL 06-05-03

2.0 D33557 small tubing



made by hand



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)  
pick: 6.875

2.75

3.47

Qty Part number Description Batch  
1 D3355-7 small tubing M16999

M1018TR1-000W095

CPL 06-05-03

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
Weld assembly as per dwg

CPL 06-06-01

4.0 QC5/9 WELD INSPECTION



Jan 06-21 (4)



Comment: WELD INSPECTION

06/04/01 (4)

5.0 POWDER COATING POWDER COATING



Comment: POWDER COATING  
Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

DL 06/08/06 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/08/27

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Wednesday, 5/3/2006 2:08:55 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 26924

Part Number: D3355047

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*6/1/12 (4)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *51251*

*6/8/12 (4)*

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*Nov.08.22*

Job Completion



*U 0608.22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

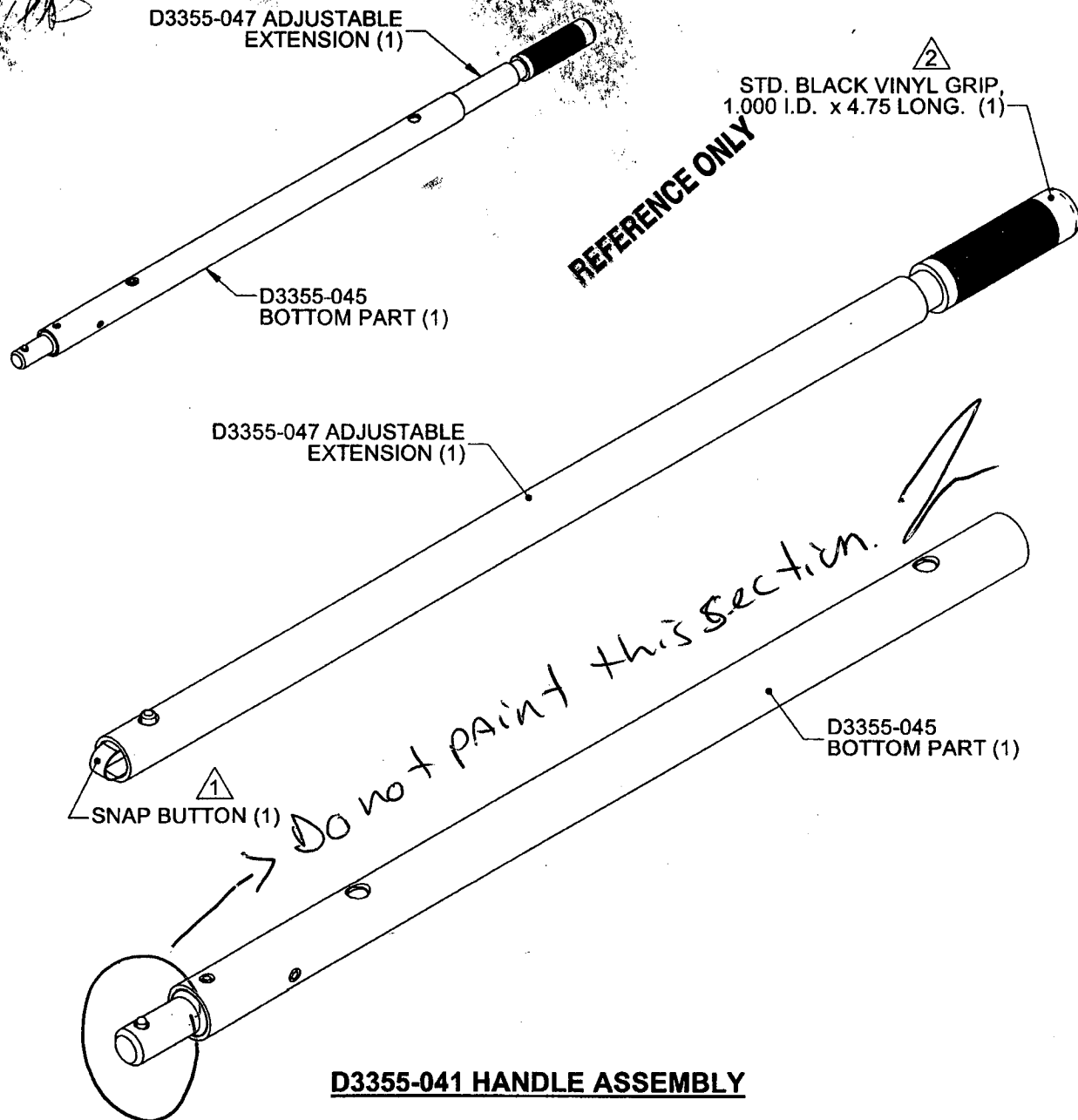
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3355	REV. A SHEET 1 OF 6
DATE 05.02.07	TITLE HANDLE WELDMENT		SCALE 1:8
A	05.02.07	NEW ISSUE	

RELEASED  
06/03/07




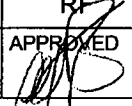
**NOTES:**

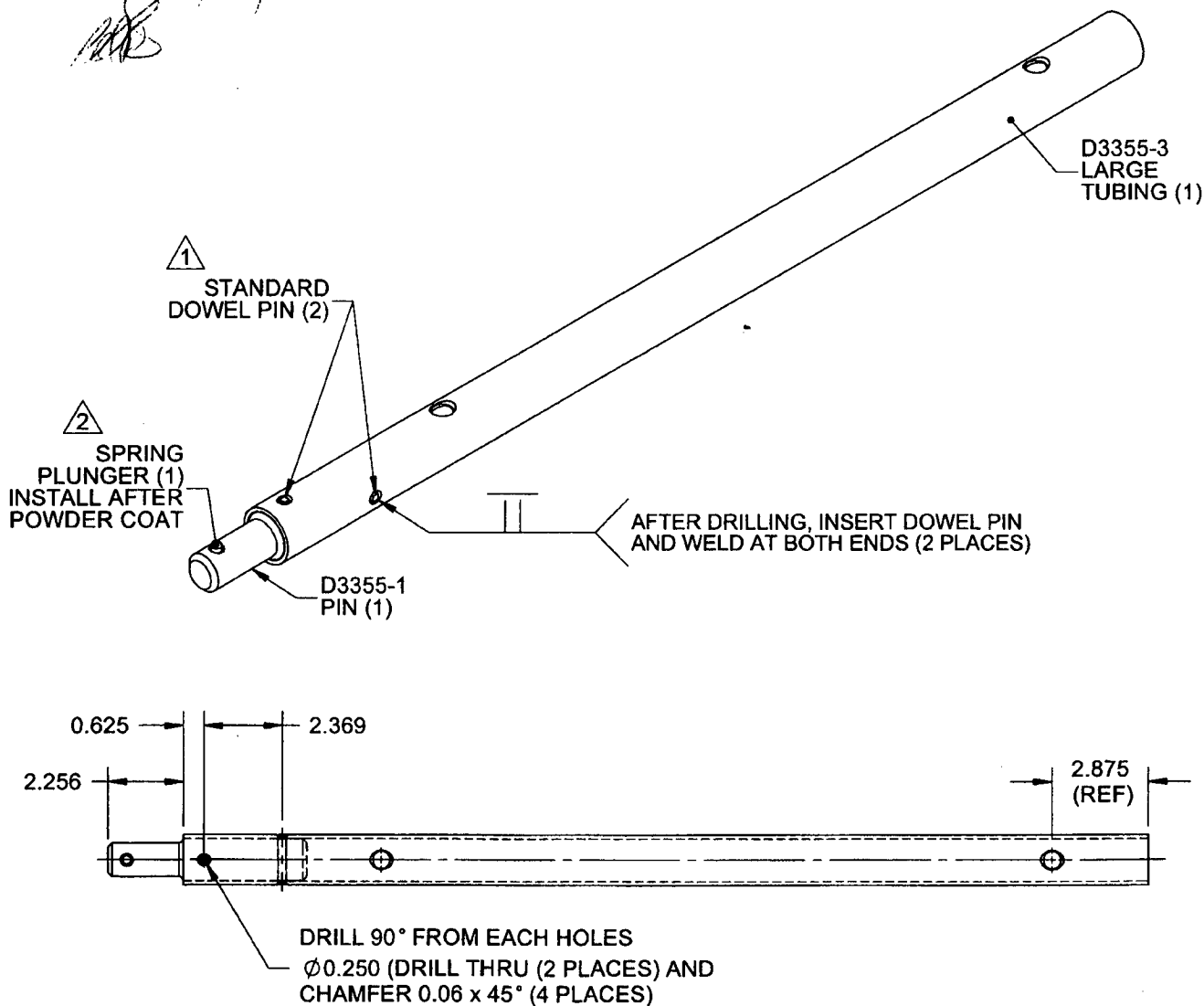
- 1) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N VA-2160
- 2) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N GP-1R

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DATE <b>05.02.07</b>		TITLE <b>HANDLE WELDMENT</b>	SCALE 1:5

**RELEASED**  
*06/03/07***D3355-045 BOTTOM PART****NOTES:**

- 1) STEEL STANDARD GROUND DOWEL PIN, Ø0.250 X 1.25 LONG  
POSSIBLE SUPPLIER: SPAENAU, P/N 238-043
- 2) SPRING PLUNGER, POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N VA-7130
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.010 TO 0.020

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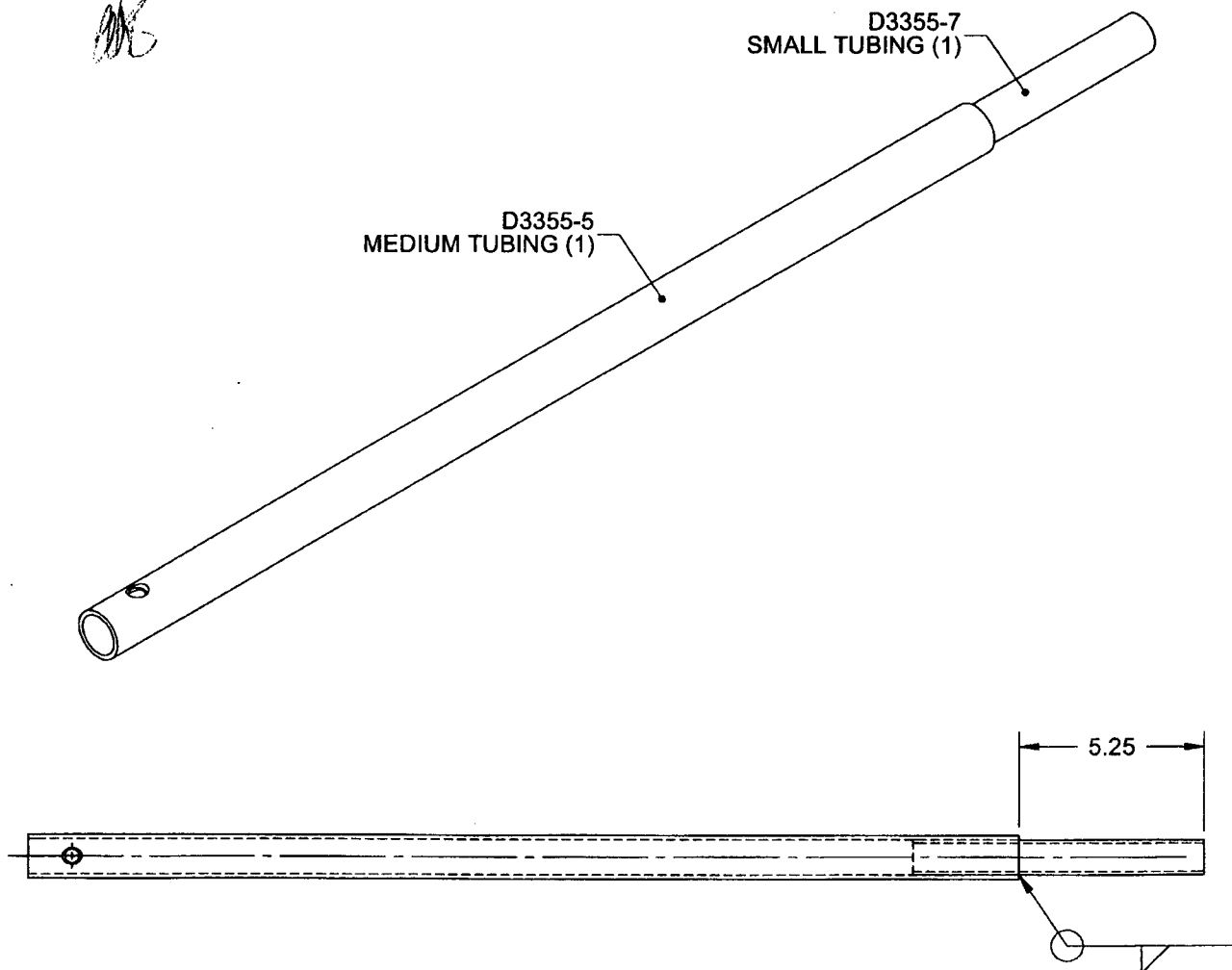
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DATE <b>05.02.07</b>		TITLE <b>HANDLE WELDMENT</b>	SCALE 1:5

RELEASED  
06/23/09

*[Signature]*



### D3355-047 ADJUSTABLE EXTENSION

#### NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

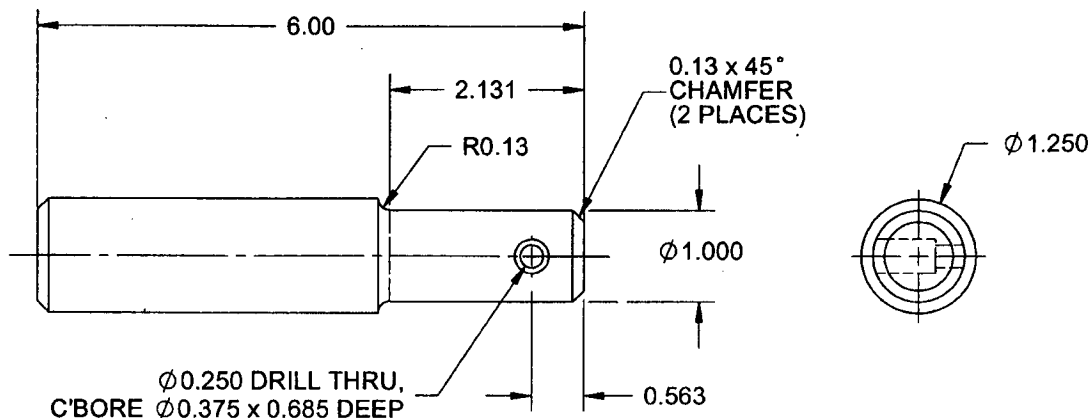
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DATE <b>05.02.07</b>		TITLE <b>HANDLE WELDMENT</b>	SCALE 1:2

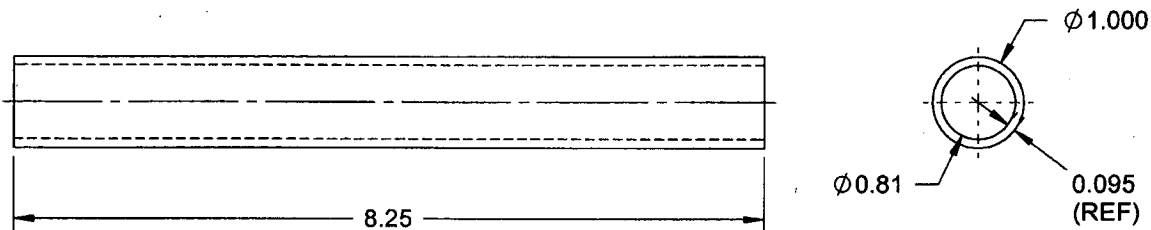
RELEASED  
26/03/07



#### D3355-1 PIN

##### D3355-1 NOTES:

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020



#### D3355-7 SMALL TUBING

##### D3355-7 NOTES:

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING (REF. DART SPEC. M1020TR1.000W.095)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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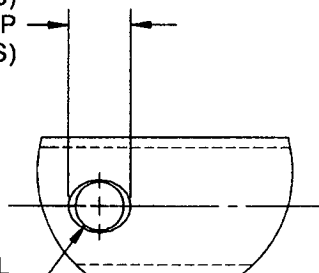
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3355</b>	REV. A SHEET 5 OF 6
DATE <b>05.02.07</b>	TITLE <b>HANDLE WELDMENT</b>		SCALE 1:6

RELEASED  
06/03/09

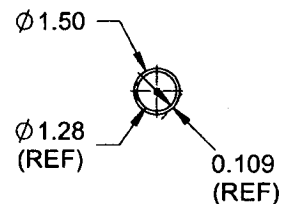
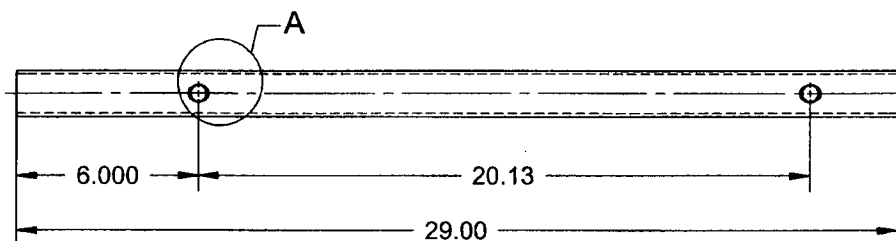
*RF*

CHAMFER  $\phi 0.687$  (11/16)  
x 45°, 0.060 DEEP  
(2 PLACES)

$\phi 0.531$  (17/32) DRILL  
THRU (2 PLACES)



**DETAIL A**  
**SCALE 1 : 2**



### **D3355-3 LARGE TUBING**

#### **NOTES:**

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING  
(REF. DART SPEC. M1020TR1.500W.109)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

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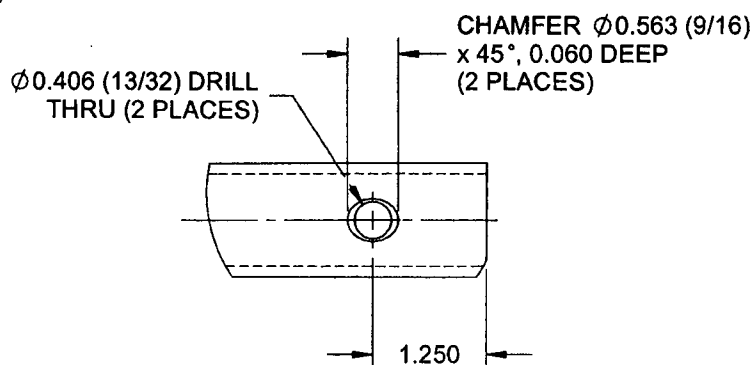
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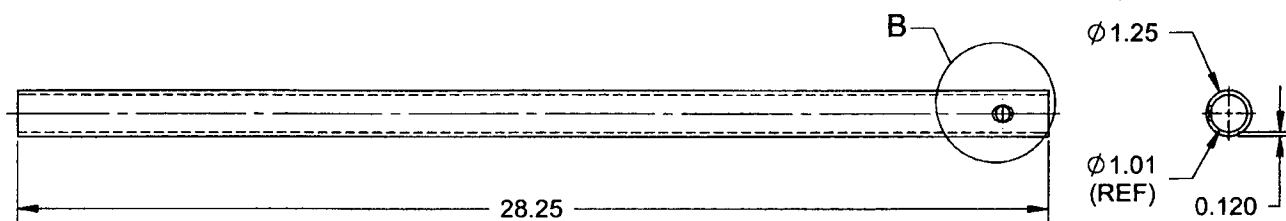
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3355</b>	REV. A SHEET 6 OF 6
DATE <b>05.02.07</b>	TITLE <b>HANDLE WELDMENT</b>		SCALE 1:5

RELEASED  
06/03/09

*[Handwritten initials]*



**DETAIL B**  
SCALE 1 : 2



**D3355-5 MEDIUM TUBING**

**NOTES:**

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING  
(REF. DART SPEC. M1018TR1.250W.120)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

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